

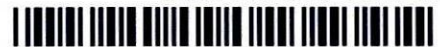


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

5036056

D2500-3-100
Job Sheet 169211



Part No: D2500-3-100

Job Qty: 167 ea

Part Name: Ext'n -I' Beam Web 4"



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 12/5/17

Job Tracking No:

Due Date: 1/15/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV H

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	167 pcs		1/15/18	0.00	0.00	Purchasing		18/01/27
110	Packaging	167 pcs		1/15/18	0.00	0.00	Packaging2		18/01/27
120	QC	167 pcs		1/15/18	0.00	0.00	QC6		18-01-27
130	Packaging	167 pcs		1/15/18	0.00	0.00	Packaging3		18-01-29
140	QC21-SA	167 Ea		1/15/18	0.00	0.00	QC21		18-01-29

Part Op 100 - Issue P/O: 38626 a) Extrude as per Dwg D2500 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield
Descriptions: tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 190" long
g) Bon-L-Canada Inc. tool # 897105 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material
certification is required

110 - Ensure material certification is attached

120 - Check Pull test per Dwg D2500 for compliance page attached. Check hardness with Webster tester

130 - LOCATION - LG002 MAIL

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	D2500-3-100P	167	0	0	0

Part Specifications

Specifications could not be found.

Plex 12/12/17 11:13 AM dart.lavoie.chantal



S036056



Ext'n - 'I' Beam Web 4"

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO: D2500-3-100

Original Serial #: S036056

Revision:

Operation:

Change No:

Purchasing

Mfg Date: 01/27/18

Job No: 169211

SPECIFICATION CONTROL DRAWING

D2500-1-XXX EXTRUSION & D2500-3-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: D2500-1 = 0.143 lb/in, D2500-3 = 0.086 lb/in

8) FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG). D2500-1 EXTRUSION MANUFACTURED FROM:

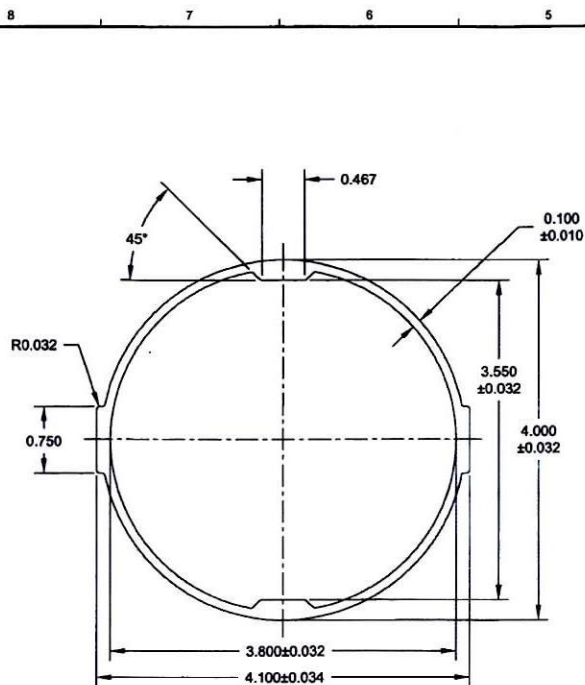
- A) BON L DIE # 987105 -> PREFERRED
- B) CARADON MIDEAST DIE # PAH-28030
- C) CARADON MTL DIE # MH-18888

9) FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG). D2500-3 EXTRUSION MANUFACTURED FROM:

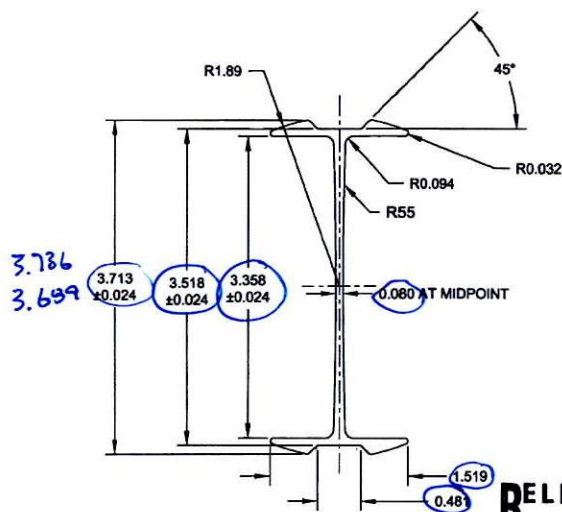
- A) CARADON INDALEX DIE # MS-18867

RELEASED
2010-02-02
MT

H	REDRAW & REFORMAT DWG; CORRECT BON L DIE # TYPO (ZN B8-1). ADD AMS & ASTM MAT'L OPTION (ZN D6-1). TOLERANCES NOW PER CARADON DWG (SHT 2)	CP	09.07.16
G	ADD DIE NUMBERS & DIMS IN INCHES NOTES	PH	07.04.17
F	CHANGE MAT. TO 6061-T6	DS	07.09.29
E	CHANGE MATERIAL TEMPER	DS	06.10.24
D	ADD MATERIAL PROPERTIES	DS	06.10.07
C	ADD D2500-3 WEB	BW	06.04.26
B	CHANGE INTERNAL WEB	DS	06.03.24
A	NEW ISSUE	DS	06.03.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2500 TITLE EXTRUSION REV. H SHEET 1 OF 2 SCALE NTS COPYRIGHT © 1995 BY DART AEROSPACE LTD This document is controlled under the provisions of the DART AEROSPACE LTD. Information Management System. It is not to be released, copied, or otherwise used without the written permission of DART AEROSPACE LTD.			



D2500-1



D2500-3

RELEASED
2010-07-02
MP

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D2500 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		EXTRUSION NTS
DATE	09.07.16	COPYRIGHT © 1998 BY DART AEROSPACE LTD



Adresse Postale: Sapa Canada, Inc
325, rue Avro
Pointe-Claire Québec H9R 5W3
Téléphone:(514)697-5120
Télécopieur: (514) 694-8310

Packing Slip / Détail de Livraison

Packing Slip No / 117337
Bon de Livraison
Order no/ 7120653 1
Commande

Ship to/Expediée à DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7				Sold to/Vendu à DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7				Special Instr / Instr. Spéciales			
Cust No/No du Client 201355		Cust No/No PO du Client 38626		PPD/PAYÉ X		Ord Dte/Dte Comm 17/12/12		Our Ord Dte/ Notre Dte la Comm 17/12/12		Sapa G.S.T #: R857314058	
PST/TPV * 6122-5207				Terms/Cond		Date Required/ Date Requite		Shipped/ Expediée 18/01/25		Shipped Via/ Expediée Par OTTAWA 26 JAN	
Item No	Ordered Weight Pcs/ Commande Poids Pcs	Sapa Die no/ Matrice d'Sapa	Customer Description/ Description de Client	Alloy & Temper/ Alliage et Trempage	Length Longueur	Backorder Wgt Pcs Arrière Poids Pcs	This Shipment Bdls Wgt Pcs Com Expediée Ballots Poids Pcs				
1	499 167		DUE = 2018/01/19 JA15 D2500-3 MS 18867 D2500-3-100 6061 T6 2540MM BUNDLE = 1336215 1336217 We hereby certify the material supplied meets the chemical properties as published by the Aluminu Assoc., and requirements of our Quality Procedures		m	2 342	124 POIDS EN KGS				

Aluminum Extrusions - Anodizing - Fabrication - Painting
Profils D'Aluminum - Anodisation - Fabrication - Peinture

The above items were received in good order.
Les articles ci-dessus ont été reçu en bon ordre.

By/Par.....

CUSTOMER COPY

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 02500-3-100

PO / BATCH NO.: 38626 / 5086056

DATE: JAN 27 2018

MATERIAL CERT REC'D: yes

THICKNESS ORDERED: 0.080 at midpoint

QUANTITY RECEIVED: 124 + 47 PCS

THICKNESS RECEIVED: 0.080 at midpoint

QUANTITY INSPECTED: 124 + 47 PCS

SHEET SIZE ORDERED: N/A

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y <u>N</u>	
CORRECT FINISH	<u>Y</u> N	
CORROSION	Y <u>N</u>	
CORRECT GRAIN DIRECTION	<u>Y</u> N	
CORRECT MATERIAL PER M-DRAWING	<u>Y</u> N	as per drawing 02500
CORRECT THICKNESS	<u>Y</u> N	
PHOTO REQUIRED	Y <u>N</u>	
CORRECT REF # TO LINK CERT	<u>Y</u> N	PO 38626
CORRECT MATERIAL IDENTIFICATION	<u>Y</u> N	
CORRECT M# ON THE MATERIAL	<u>Y</u> N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y <u>N</u>	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y <u>N</u>	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS 11</u>	SIGNED OFF BY: _____
DATE: <u>9-89 JAN 27 2018</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in